

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029540**Date Inspected:** 17-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds and fillet welds of the East and West Orthotropic Box Girders (OBG's). The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

This QAI observed the weld preparation, grinding and welding in progress of the seal cover plates at location 12E-PP119(-1500)-E3 per AB/F RFI #003256R00. The welder Earl Clayborn #5070 utilized the required E7018 electrodes as per the WPS ABF-WPS-D15-F1200A. The AB/F Quality Control (QC) Inspector William Sherwood was present, monitoring the WPS parameters of the welding in progress.

This QAI performed the Magnetic Particle Testing (MPT) verification inspection of the Deck Access Hole (DAH) at location 12E-PP116.5-E2. There were no indications noted at this time. See the attached TL-6028 MT report for details. The AB/F Quality Control (QC) Inspector Bonafacio Daquinag Jr. had performed his MT final inspection on this weld previously. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI witnessed the proper preheat to 325F for seal cover plates at location 12E-PP119(+1500)-E3 as per the AB/F RFI #003256R00. The welding was performed by, Lin E. Yun #9344, is in progress and approximately 90%

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complete. The E7018 electrodes were utilized as per the requirements of WPS ABF-WPS-D15-F1200A. The AB/F Quality Control (QC) Inspector William Sherwood was present, monitoring the WPS parameters of the welding in progress.

Summary of Conversations:

No significant conversations took place.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris, Monty	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
